

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83941

83941

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Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 27/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Press Fit D2809 as per Dwg D2804								
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00							
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

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83941

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N900040100

Setup Start ***NS1***

Stop ***NS2***

4

4

Run Start *NR1*

Stop *NR2*

Date:

**Insp.
Stamp**

0.00/

0.00

0.00

0.00

0.00

0.00

Quality Control

12/6/14 *[Signature]*
MLJ 12/06/13

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Picklist Print

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Work Order ID: 83941

83941

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	0.0000	1	4			
D2804-2													
Bracket													
D2805-2		Manufactured	No			100	Each	13.0000	1				
D2805-2													
Stop													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			13						
				81073			13						
NAS1515H3		Purchased	No			100	Each	190.0000	4	16			
NAS1515H3													
Washer													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST277			190						
				118078			6						
				119438			4						
				120142			11						
				120518			26						
				120770			43						
				121415			100						

B82550 (6) **

EB12/06/05

**

EB12/06/05

6

EB12/06/12

**

1121649
(24x)

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Page 2

Work Order ID: 83941

83941

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

68.0000

2

8

AN3C16A

Bolt

**

EP 12/06/12

Location

Loc Qty

Loc Code

ST352

68

115835

1

118422

4

120498

38

121349

25

12

D2809

Manufactured

No

150

Each

40.0000

1

4

D2809

Bushing

**

EP 12/06/12

Location

Loc Qty

Loc Code

GA

24

72735

7

80557

17

ST018

16

34035

12

77292

4

B85299
(6x)

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Shop Packet Print

Page 2

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April-27-12 2:53:30 PM

Page 3

Work Order ID: 83941

83941

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

150

Each

1,097.000

2

8

MS21043-3

**

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

124

120693

124

ST301

901

118077

2

118614

83

118686

30

119758

20

121255

766

E. B. 2/6/12

M121708
(127)

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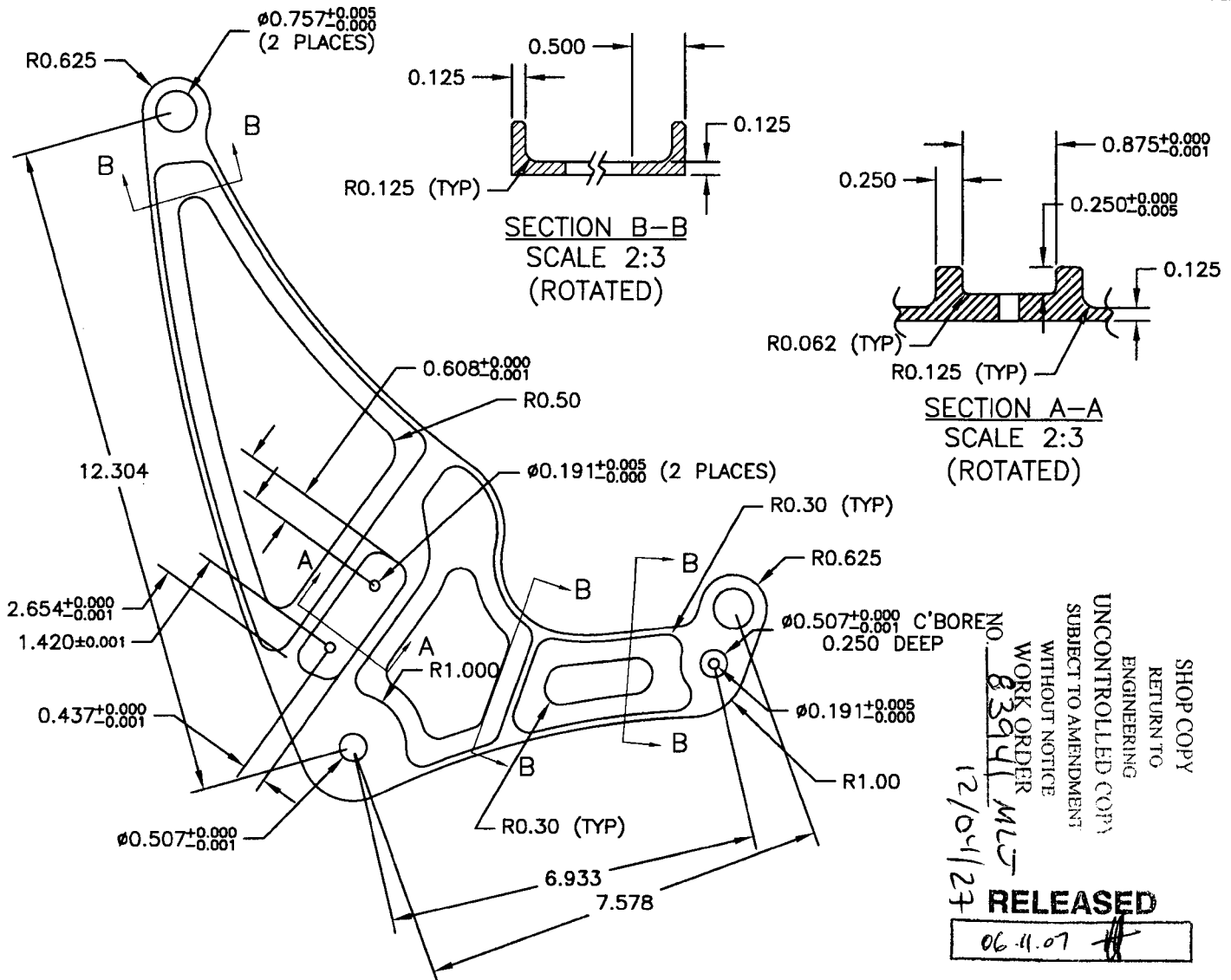
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83941 MLC
12/04/27
RELEASED
06.11.07 [Signature]

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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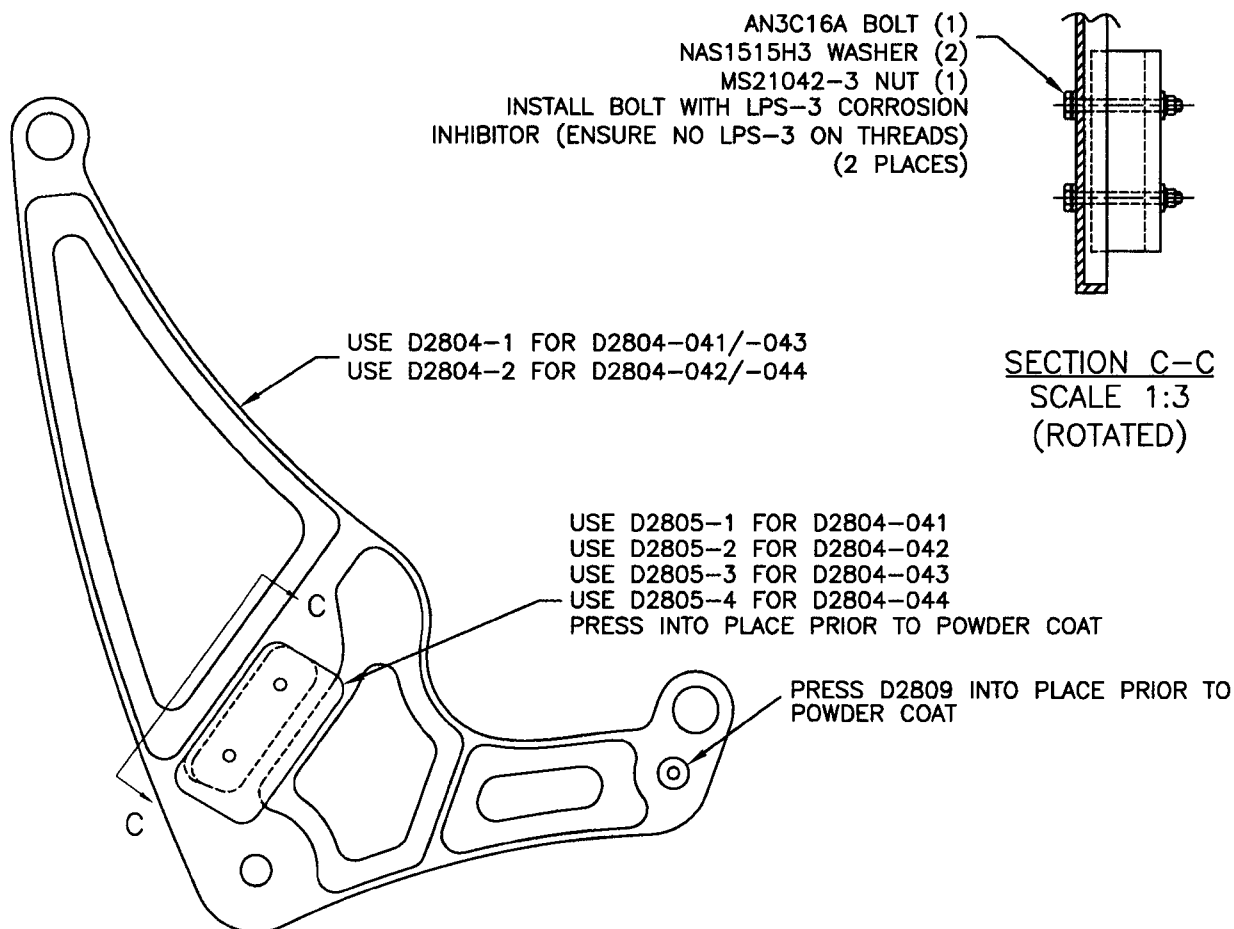

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

**RELEASED**06.11.07 

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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